

DEPARTMENT OF TRANSPORTATION**DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch

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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.21**WELDING WITNESS REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WWR-000357**Date Inspected:** 25-Jul-2007**Project Name:** SAS Superstructure**OSM Arrival Time:** 800**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1730**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**Witness:** **Procedure Qualification Record**
Welding **NDT****Welder Qualification** **Fracture Critical**
Mechanical Testing, describe:**Index Lot #:** B71-047-07a**Witness Lot #:** B71-047-07**Bridge No:** 34-0006**Component:** Bid: 52,55 Tower & Girder**Welder:** Zhu Hai Ping**ID #:** N/A**Joint Description:** B-U2a

N/A

WPS ID #: PWPS-B-T-3214 Rev. 1

N/A

Base Metal: A709M HPS 485 W

N/A

PQR ID #: HP2007249-1

N/A

Thickness: 25 mm

N/A

Process: SMAW

N/A

Electrode Spec/Class: AWS-A5.1/E-7018-1

N/A

Positions: 4-G

N/A

Backing Material: A709 HPS 485 W

N/A

CWI: Huang Wei and Xu Bing

N/A

Average Amps: 161.8

N/A

AWS Code: AWS D1.5 (2002)

N/A

Average Volts: 22.6

N/A

Applicable Sec: AWS 5.13

N/A

Travel Speed: 101 mm/min

N/A

Heat Input: 2.16 KJ/mm

N/A

Preheat: 125 Celsius

N/A

Summary of Items Observed:

The Caltrans Quality Assurance (QA) Inspector was present as requested to witness the welding of the Procedure Qualification Record(PQR) test plate HP 2007249-1 using the shielded metal arc welding (SMAW) electrode specification/classification A5.1/E-7018-1 brand name THJ506Fe-1, diameter of electrode 4.0 mm in the 4-G position. The welding was performed per the AWS D1.5, Section 5.13 Production Procedure WPS. Total of passes/layers were 17 passes and 7 layers. The welding of the test coupon appeared to be in compliance with the contract documents.

The QA inspector did not observe any significant air movement by testing area during welding.

Summary of Conversations:

The QA inspector did not have any significant conversations on this date.

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is in general conformance with the contract requirements.

Observed welding,testing or results:

is not in conformance with the contract requirements.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Mazen Wahbeh, (818) 292-0659, who represents the Office of Structural Materials for your project.

Inspected By: Acuna,Alfredo

Quality Assurance Inspector

Reviewed By: McClary,David

QA Reviewer
